

Work Order ID 85000

85000

Page 1

May-31-12 8:56:51 AM

Item ID: D412-698-027

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Bracket Assembly, LH (Aluminum Doors)

Stop

NS2

Start Date: 5/31/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/31/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

V

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
DSI 9484	C								

100

100

DC

Document Control

Memo

0.00

0.00

1 12.05.31

MLJ 12/05/31

110

110

Packaging

Packaging

Pick Kit

0.00

12/13/31

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

0.00

1 12.05.31

Work Order ID 85000***85000***

Page 2

May-31-12 8:56:51 AM

Item ID: D412-698-027

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket Assembly, LH (Aluminum Doors)

Stop

NS2

Start Date: 5/31/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/31/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-698-027/ DSI 9484

Location: _____

PPP rev: _____

12/5/31

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MLJ 12/05/31

MW 12/05/31

Picklist Print

May-31-12 8:56:51 AM

Page 1

Work Order ID: 85000

Parent Item: D412-698-027

Parent Item Name: Bracket Assembly, LH (Aluminum Doors)

Start Date: 5/31/12

Required Date: 5/31/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
ECN11-531 verified by:EC

IPP Rev:B 11.03.31 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3199-3 Bracket, Fwd LH		Manufactured	No			110	Each	30.0000	1	1	1	1	

Location	Loc Qty	Loc Code
ST236B	30	
75206	13	
77361	17	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E OR LATER APPROVED REVISION
AND ICA-D412-698 REV. 5 OR LATER APPROVED REVISION

REF. TCCA STC: SH92-43
REF. FAA STC: SR01446NY
REF. EASA.IM.R.S.00709

Field experience has shown that the forward D3199-1 brackets that are part of the D412-698-011/-012/-017 Cabin Door Roller Kits and forward D3675-1 brackets that are part of the D412-698-031/-032/-033 Cabin Door Roller Kits may wear prematurely if the aircraft is flown a significant amount of time with the sliding doors open. Dart has developed the D412-698-027/-028 kits that includes a longer D3199-3/-4 bracket for installation in the first forward position of the D412-698-011/-012/-017 kits to reduce wear on these forward brackets on aircraft equipped with aluminum doors. Likewise, Dart has developed the D412-698-037/-038 kits that includes a longer D3675-5/-6 bracket for installation in the first forward position of the D412-698-031/-032/-033 kits to reduce wear on these forward brackets on aircraft equipped with composite doors.

The D412-698-027/-028/-037/-038 kits may be installed as follows:

- 1) Remove the sliding door from the aircraft per Section 52.1 of ICA-D412-698
- 2) Remove the first forward D3199-1 or D3675-1 brackets as applicable.
- 3) Install the D3199-3/-4 or D3675-5/-6 bracket as applicable in lieu of the removed -1 bracket. Refer to Figure 1 Sheet 2 (aluminum doors) or Figure 2 Sheet 3 (composite doors).
- 4) Torque hardware per ICA-D412-698.
- 5) Re-install sliding door on aircraft per Section 52.2/52.3 of ICA-D412-698 as applicable.
- 6) Make entry in technical records of aircraft indicating that DSI 9484 has been completed.

PARTS LIST

QTY -027	QTY. -028	QTY. -037	QTY. -038	PART NUMBER	DESCRIPTION
X				D412-698-027	BRACKET KIT, LH (ALUMINUM DOORS)
	X			D412-698-028	BRACKET KIT, RH (ALUMINUM DOORS)
		X		D412-698-037	BRACKET KIT, LH (COMPOSITE DOORS)
			X	D412-698-038	BRACKET KIT, RH (COMPOSITE DOORS)
1				D3199-3	FORWARD BRACKET, LH
	1			D3199-4	FORWARD BRACKET, RH
		1		D3675-5	FORWARD BRACKET, LH
			1	D3675-6	FORWARD BRACKET, RH

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal		Applicability
		Arm	Moment	Arm	Moment	
D412-698-027 Bracket Kit	0.16 lb 0.07 kg	-48.0 in -1.22 m	-7.68 in-lb -0.09 m-kg	102.3 in 2.60 m	16.37 in-lb 0.18 m-kg	Aircraft Equipped with P/N 205-032-669-XXX Aluminum Doors
D412-698-028 Bracket Kit	0.16 lbs 0.07 kg	+48.0 +1.22 m	+7.68 in-lb +0.09 m-kg	102.3 in 2.60 m	16.37 in-lb 0.18 m-kg	
D412-698-037 Bracket Kit	0.18 lb 0.08 kg	-48.0 in -1.22 m	-8.64 in-lb -0.10 m-kg	102.3 in 2.60 m	18.41 in-lb 0.21 m-kg	Aircraft Equipped with P/N 412-030-300-XXX Composite Doors
D412-698-038 Bracket Kit	0.18 lb 0.08 kg	+48.0 in +1.22 m	+8.64 in-lb +0.10 m-kg	102.3 in 2.60 m	18.41 in-lb 0.21 m-kg	

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-0-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	11.03.21
CERT. NO.:	SH92-43
ISSUE NO.:	5

C	UPDATED -027/-028/-037/-038 KITS AND INSTALLATION			MB	11.03.21
B	ADDED -037/-038 KIT FOR COMPOSITE DOORS; UPDATED TITLE ACCORDINGLY.			MB	10.12.17
A	NEW ISSUE			<i>[Signature]</i>	09.10.16
REV.	DESCRIPTION			BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. DSI 9484 REV. C SHEET 1 OF 3 TITLE D412-698-027/-028/-037/-038 Kits SCALE NTS			
DRAWN	<i>[Signature]</i>				
CHECKED	<i>[Signature]</i>				
MFG. APPR.	<i>[Signature]</i>				
APPROVED	<i>[Signature]</i>				
DE APPR.	<i>[Signature]</i>				
DATE	11.03.21				

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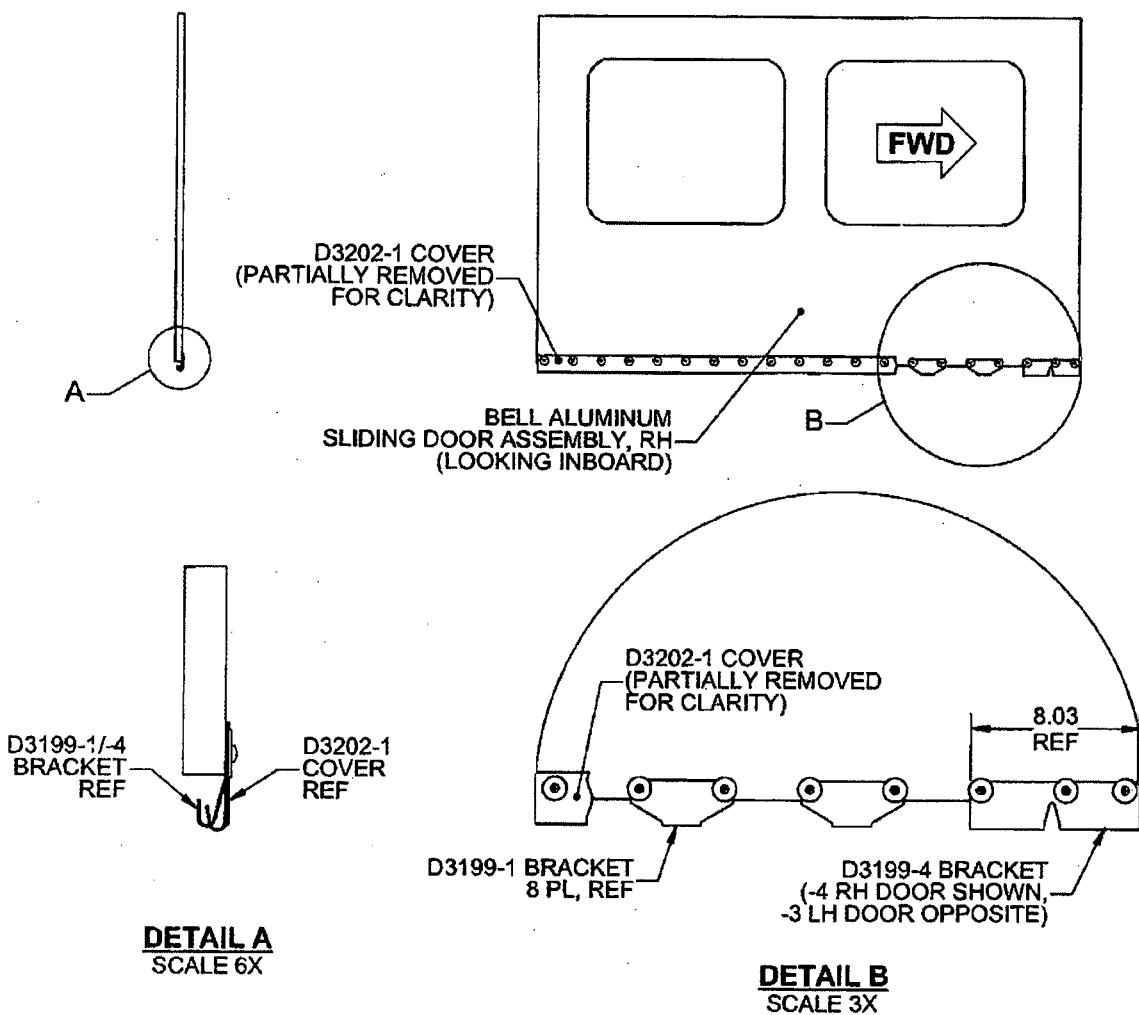


FIGURE 1: D3199-3/-4 BRACKET INSTALLATION ON ALUMINUM DOORS
(-4 SHOWN, -3 OPPOSITE)

canada
department of transport
aircraft certification
branch
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

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ISSUE NO.: 5

9080c

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MFG. APPR.	N/A	DS1 9484	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	
DE APPR.	<i>[Signature]</i>	D412-698-027/-028/-037/-038 Kits NTS	
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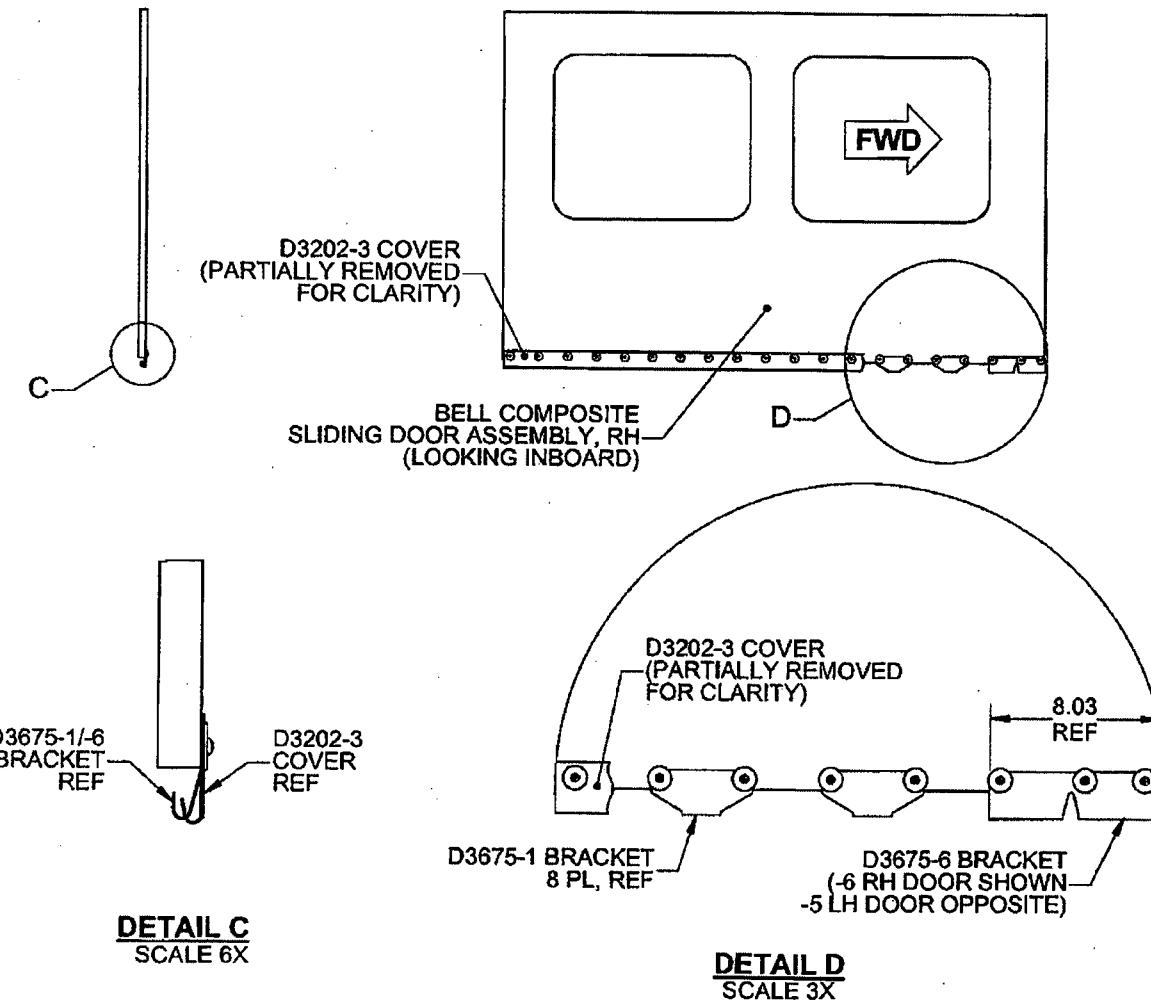


FIGURE 2: D3675-5/-6 BRACKET INSTALLATION ON COMPOSITE DOORS
(-6 SHOWN, -5 OPPOSITE)

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BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	11.03.21
CERT. NO.:	SH92-43
ISSUE NO.:	5

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APPROVED	<i>[Signature]</i>	TITLE	
DE APPR.	<i>[Signature]</i>	D412-698-027/-028/-037/-038 Kits NTS	
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